

Wednesday, 17/09/2008 3:56:37 PM
Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 42079
 Estimate Number : 13582
 P.O. Number :
 This Issue : 17/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run :
 Written By : 08-09-17
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-09-17 JLM Verified By:EC

Part Number : D38201
 Drawing Number : D3820 PREL
 Project Number : N/A
 Drawing Revision : PREL
 Material :
 Due Date : 24/09/2008 Qty: 3 Um: Each

FOR ESTIMATE USE ONLY

proto u

Additional Product

PRELIMINARY ISSUE

POSITIVE
RECALL

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S125 6061-T6 .125 Sheet



IS MAT NOT PULLED



Comment: Qty.: 0.0543 sf(s)/Unit Total: 0.1629 sf(s) 1B 8-10-2
 6061-T6 .125 Sheet 108730 1B 8-9-29

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3820

1B 8-10-2

Dwg Rev: PRE L.

1B 8-9-29

Prog Rev: PRE L.

1B 8-10-2

2-Deburr if necessary

1B 8-9-29

(3)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



1B 8-10-2



1B 8-9-29

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08-10-01 (3)
08-10-02 3

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3820

SB 08/10/03

(3)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 42079

Part Number: D38201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



08.10.06 (3)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/10/06 (3)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

N/A u per Prod 08.10.03

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



HARLEY -> Eagle.



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock Location: _____

AS 08/10/06 (X3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE

RELEASED

AUTH

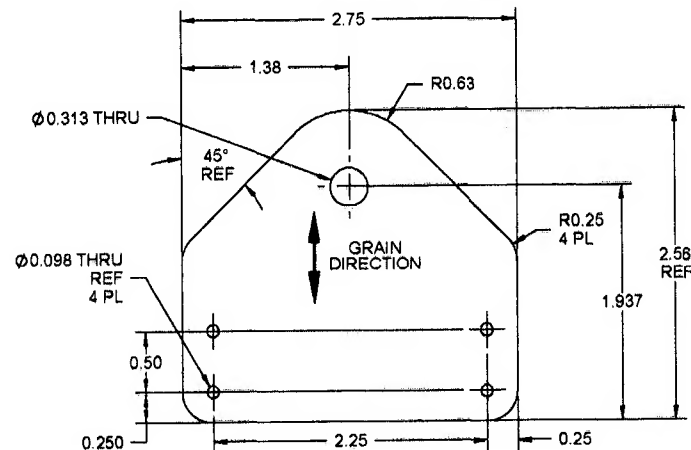
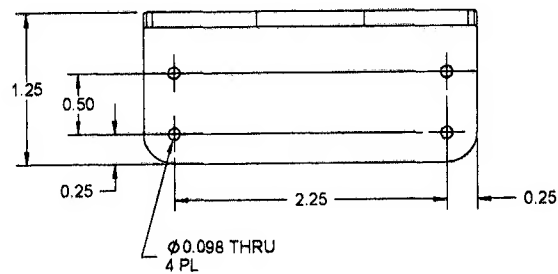
DATE

00252A

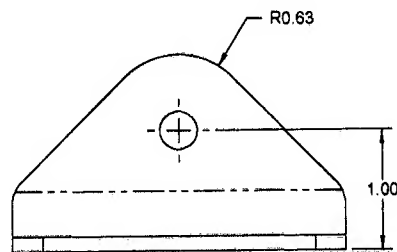
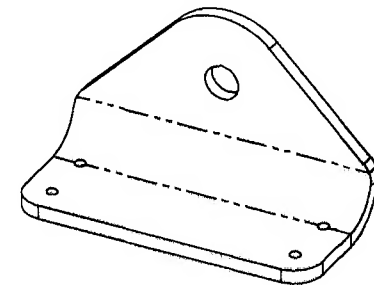
u 08.10.06

u

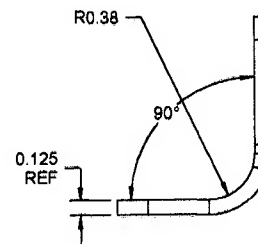
3 parts scrap due to we did not have.
1/4" die, Evg changed to .375
Paul.



D3820-1F BRACKET FLAT PATTERN



D3820-1 BRACKET
(MADE FROM D3820-1F)



NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET X 0.125 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3820-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		08.10.02
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.10.02		


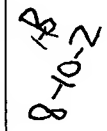

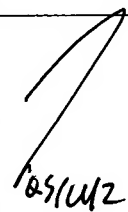


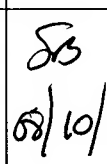


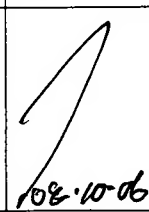
PRELIM ISSUE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3820**
REV. A
SHEET 1 OF 1
TITLE **BRACKET**
SCALE
NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-10-06	5.0	3 parts scrap. - Parts did not meet the dwg due to incorrect die's being used. Dwg asked for R.250", and a R.3/8 was used, and also identified as a 1/4" die. R.C. Tools are not identified correctly, and are clearly not measured to ensure the tool is the correct size.		- Scrap: replace 2x sets of 3.	 8-10-06	 08-10-06	 08/10/06	 10-10-06
				- Ensure all tools ^{and} are material are measured prior to use, regardless of the identification.	 08/10/06	 08-10-06	 08/10/06	 10-10-06

NOTE: Date & initial all entries

